

Work Order ID 81365

81365

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March-13-12 1:38:46 PM

Item ID: D2620 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube, 206 Skidtube
 Start Date: 13/03/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLC Date: 12/03/13 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2620	Rev B

100	Skidtubes	0.00							
100									
Skidtubes	Memo	0.00							
Skidtubes	1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft0082- Cut Fwd end of tube as per Dwg D2620								

11 CF/QC 12-3-13
12/03/13

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

DP 12-3-16

120	Identify as per dwg & Stock Location: <u>46</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

QC 12/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81365***81365***

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Item ID: D2620

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Skidtube, 206 Skidtube

Start Date: 13/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/3/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 81365

81365

Parent Item: D2620

D2620

Parent Item Name: Skidtube, 206 Skidtube

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D02.07.26Change Dwg to rev.B; Updated LocationRF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-1-160

Manufactured

No

100

Each

122.0000

1

10

D2600-1-160

Extrusion Round 3" 206

**

11

CF/ 12-3-12
PK 02/03/13

Location

Loc Qty

Loc Code

LG

122

43969

2

59875

1

68284

37

76913

82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

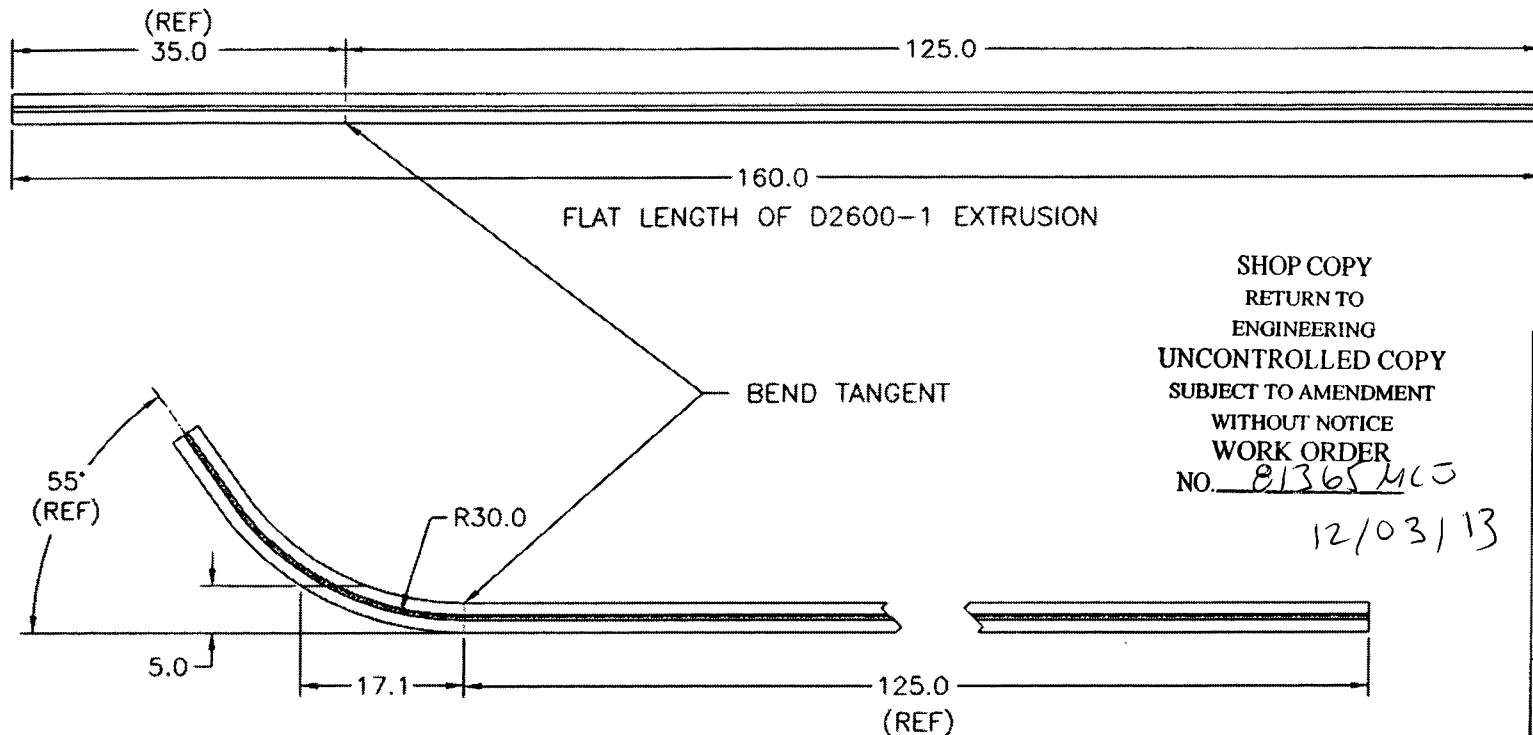
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81365 MCO
12/03/13

DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
49.04.15 DS

DESIGN	99.09.10	DRAWN BY	RF	DART AEROSPACE USA, INC.
CHECKED		APPROVED	KE	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	99.09.10	TITLE	D2620	REV. B
	A		97.11.07	
	B		97.09.10	
			NEW ISSUE	
			UPDATE FOR IN-HOUSE BENDING	
			206 SKIDTUBE BENDING CONTROL	
			1:20	
			SHEET 1 OF 1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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